

Amendments to the Specification

Please amend the specification as follows:

1. Please replace paragraph [0062] with the following rewritten paragraph:

[0062] The method is further shown and described below, but generally uses a multi-shot molding technique (e.g., injection molding, spin molding, transfer molding, over molding, or the like) to produce a one-piece, multi-color/multi-material trim panel. The mold includes a first mold section (shown as a core 24), a second mold section (shown as a cavity 22), and a shut-off member or retractor 26. The first "shot" of polymeric resin material (representative of a first portion 18 of trim panel 110 or 111) is constrained within the mold corresponding to a particular region on the trim panel by a first cavity defined by the retractor 26, core 24, and cavity 22. Once the first cavity is filled with polymeric resin, the retractor ~~26~~ 26 is displaced (preferably by approximately the thickness of the part) to provide a second cavity 23 defined by the displaced retractor 26, cavity 22, core 24, and the first polymeric resin. The second "shot" (representative of a second portion 20 of trim panel 110 or 111) then fills the second cavity with polymeric resin that flows to and bonds with the first material boundary. According to an exemplary embodiment, the second shot is provided by a secondary injection unit. Preferably, the retractor 26 provides the shut-off for the polymeric resin by not contacting the mold such that there is a space or gap between the retractor and the opposing mold section, which is intended to provide a vent to allow air to escape from the first cavity as the resin fills the first cavity. As such, the retractor is not required to actually contact the cavity surface in the first position to stop the flow of material into the second cavity. Instead, depending on the viscosity of the molten resin, the retractor may be offset from (e.g., not in contact with) the second mold section (i.e., the core). As such, the retractor may either shut off against the core or be offset relative to the core. According to a preferred embodiment, the first material is at least partially solidified when the second material is injected.

2. Please replace paragraph [0071] with the following rewritten paragraph:

[0071] The retractor that forms part of the shut-off can be perpendicular to or at an angle relative to the direction of the die (mold, tool, etc.) draw. According to an exemplary embodiment (shown in FIGS. 6 through 9), the perpendicular retractor surface is configured to provide a "square" recess (e.g., ditch, indent, etc.) at the two-shot boundary. According to another exemplary embodiment (shown in FIGS. 10 through 13), an angled shut-off 28 (shown as a surface of a retractor 26) is configured to provide an angled recess ~~36~~ 36a that is intended to allow the two-shot boundary to be hidden from the occupant's sight for most in-car positions. This angled shut-off 28 creates an apparent geometric gap or transition that may be more desired (for some molded articles) than a square, mechanical recess because it can hide the material joint. Such a configuration may be used to hide the interface between skin 122 and substrate 120, and/or hide the interface between the two-shot boundary.

3. Please replace paragraph [0078] with the following rewritten paragraph:

[0078] FIGS. 10 and 11 illustrate movement of a retractor 26 to provide for the first cavity and then the second cavity during the molding operation. Referring to FIG. 10, for the first shot ~~30~~ 18, the retractor 26 closes-off on the cavity-half of the mold to prevent the first shot from entering into upper portion of tool (shown as the second cavity). The first shot is injected into the first cavity.

No new matter has been added.